

Work Order ID 148785 - 2

148785

Page 1

July 08, 2016 10:32:46 AM

Item ID: PB67-43001-03

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016 Start Qty: 3.00

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: 34 Date: 7/12/16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-03	Rev C								
100		0.00							
100	Small Fab								
Small Fab	Memo	1.44							
Small Fab	1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2. 242 THREADLOCK batch: <u>134416</u>								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	Identify as per dwg & Stock Location: _____	0.00							
120									
Packaging	Memo	0.01							
Packaging									

2 AUG 28 2016 DAS 24 9-89

(2) AUG 30 2016 DAS 38 9-89

2X AUG 31 2016 DAS 28 9-89

APP 150734
APP 150015

Split

X 2

2 *P* SA
2 *P* SA

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐	

Work Order ID 148785

July 08, 2016 10:32:46 AM

148785

Page 2

Item ID: PB67-43001-03

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 8/3/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.05							
Quality Control									

DAS
21
9-89

SEP 01 2016

MF
16-8-31

Picklist Print

July 08, 2016 10:32:45 AM

Page 1
14

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 08-07-30 new issue DD verified by:ec
IPP Rev:B 08-12-04 up date part list DD Verified by:ec IPP Rev
C 10.09.24 as per Rev C dwg EC verified by:DD IPP Rev:D 10.10.21
added NAS1149F0532P DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
240-107 ✓ *240-107* ✓ SPRING SLOTTED PIN		Purchased	No			100	Each	204.0000	8	24		AUG 02 2016	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST579		204							
				m132006		36							
				m134651		168							
30345T21 *30345T21* LANYARD		Purchased	No			100	Each	18.0000	1	3			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST570		6							
				M132610		6							
				ST581		12							
				M135014		12							
30345T24 *30345T24* LANYARDS		Purchased	No			100	Each	16.0000	3	9			DAS 26 9-89
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST581		16							
				m134499		1							
				m134656		5							
				m134809		10							

JUL 28 2016

Picklist Print

July 08, 2016 10:32:45 AM

Page 2

Work Order ID: 148785

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

148785

PB67-43001-03

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

3408A98	Purchased	No	100	Each	35.0000	1	3		DAS 26 9-89
---------	-----------	----	-----	------	---------	---	---	--	-------------------

3408A98

DETENT BALL SPRING PLUNG

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST582	35	

123478

AN4-10A	Purchased	No	100	Each	158.0000	2	6		DAS 26 9-89
---------	-----------	----	-----	------	----------	---	---	--	-------------------

AN4-10A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
over003	125	
M134762	125	
ST345	33	
131677	5	
M129682	12	
M133234	16	

AN4-13A	Purchased	No	100	Each	549.0000	1	3		DAS 26 9-89
---------	-----------	----	-----	------	----------	---	---	--	-------------------

AN4-13A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
122808	20	
GA	59	
m134167	35	
m134634	24	
over003	100	
m134943	100	
ST343	370	
m134852	370	

JUL 28 2016

Picklist Print

July 08, 2016 10:32:45 AM

Page 3

Work Order ID: 148785

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

148785

PB67-43001-03

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

AN4-15A	Purchased	No	100	Each	346.0000	4	12	DAS
								26
								9-89

AN4-15A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	26	
120449	26	
over003	320	
m134955	150	
m135127	170	

AN5-26A	Purchased	No	100	Each	35.0000	1	3	DAS
								26
								9-89

AN5-26A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST337	35	
111424	35	

AN6-11A	Purchased	No	100	Each	23.0000	2	6	DAS
								26
								9-89

AN6-11A

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST335	23	
M132576	23	

AN6-16A	Purchased	No	100	Each	30.0000	2	6	DAS
								26
								9-89

AN6-16A

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST334	30	
m128650	7	
m132576	23	

JUL 28 2016

Picklist Print

July 08, 2016 10:32:45 AM

Page 4

Work Order ID: 148785

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

148785

PR67-43001-03

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

AN8-13A

Purchased

No

100

Each

15.0000

2

6

AN8-13A

Bolt

DAS

26

9-89

Location

Loc Qty

Loc Code

ST332

15

M134497

15

BSP43

Purchased

No

100

Each

44.0000

3

9

RSP43

RIVET

DAS

26

9-89

Location

Loc Qty

Loc Code

ST558

44

M132703

44

CR3213-4-05

Purchased

No

100

Each

215.0000

1

3

CR3213-4-05

RIVET

DAS

26

9-89

Location

Loc Qty

Loc Code

CCK003

100

m135056

100

CCK005

100

m135135

100

ST319

15

m134852

15

D3440-1

Manufactured

No

100

Each

6.0000

1

3

D3440-1

Tube Guide (Supersedes B67-43001-25/-307)

Location

Loc Qty

Loc Code

Mezz2

6

142150

6

Picklist Print

July 08, 2016 10:32:45 AM

Page 5

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

DAS
24
9-82

D3440-3

Manufactured No

100 Each

6.0000

1

3

103 02 2016

✓ ***D3440-3***

Clamp (Supersedes B67-43001-309)

**

3

S

Location

Loc Qty

Loc Code

Mezz2

6

142151

6

3

Manufactured No

100 Each

4.0000

1

3

103 02 2016

DAS
24
9-82

D3444-1

✗ ***D3444-1***

Velcro Loop Belt

**

Location

Loc Qty

Loc Code

Mezz2

4

133002

4

3

Manufactured No

100 Each

3.0000

2

6

103 02 2016

D3447-9

✗ ***D3447-9***

Swing Arm

**

6

S

Location

Loc Qty

Loc Code

Mezz2

3

142213

3

3

Manufactured No

100 Each

6.0000

1

3

103 02 2016

D3449-1

✓ ***D3449-1***

Pad

**

3

C

Location

Loc Qty

Loc Code

Mezz2

6

133652

6

4

Manufactured No

100 Each

1.0000

1

3

103 02 2016

DAS
24
9-82

D3451-043

✗ ***D3451-043***

Handle And Lock-Down Assembly

**

Location

Loc Qty

Loc Code

Mezz2

1

142169

1

1

3148788 → 2

July 08, 2016 10:32:45 AM

Shop Packet Print

Page 5

Picklist Print

July 08, 2016 10:32:45 AM

Page 6

Work Order ID: 148785

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

148785

PB67-43001-03

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00



D3451-045

Manufactured No

100

Each

1.0000

1

3

DAS
24
9-89

AUG 02 2016

D3451-045

Handle And Lock-Down Assembly

**

3148786 → 2

Location

Loc Qty

Loc Code

Mezz2

1

142170

1

D3922-1

Manufactured No

100

Each

36.0000

1

3

**

D3922-1

Clip

Location

Loc Qty

Loc Code

ST059

36

111733

11

148014

25

MS17984-C408

Purchased No

100

Each

8.0000

1

3

**

MS17984-C408

PIN, QUICK RELEASE

DAS
22
9-89

16.09.01

410

Location

Loc Qty

Loc Code

ST315

8

m132576

8

MS17984-C418

Purchased No

100

Each

19.0000

3

9

**

MS17984-C418

QUICK RELEASE PIN

Location

Loc Qty

Loc Code

FG

1

123482

1

over005

10

147087

10

ST315

8

m134676

8

DAS
6
9-89

135058 x1

8

Picklist Print

Page 7

July 08, 2016 10:32:45 AM

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

100

Each

2,587.000

9

27

MS21042I 4

Locknut

Location

Loc Qty

Loc Code

FP001

51

m133363

51

GA

156

m133769

156

OVER007

1000

m135127

1000

ST3003

500

m134955

500

ST303

786

m127376

12

m134861

274

m135058

500

ST305

94

m130922

94

DAS
6
9-89

27

MS21042L5

Purchased

No

100

Each

487.0000

1

3

MS21042I 5

Nut

Location

Loc Qty

Loc Code

GA

81

m127813

81

ST303

406

m134055

6

m134509

100

m134762

50

m134955

150

m135058

100

DAS
6
9-89

JUL 28 2016

3

Picklist Print

July 08, 2016 10:32:45 AM

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L6

Purchased

No

100

Each

221.0000

4

12

MS21042L6

Nut

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST303

221

m133938

6

m134055

5

m134676

50

m134955

100

m135058

60

9
3

MS24694-S109

Purchased

No

100

Each

60.0000

2

6

MS24694-S109

Screw, Flat Head

**

DAS

6

9-89

134574

Location

Loc Qty

Loc Code

Mezz

24

115708

24

ST282

36

M132576

36

MS27039-1-07

Purchased

No

100

Each

345.0000

1

3

MS27039-1-07

Screw

**

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

270

125654

270

Return2016

1

m127813

1

ST281

74

m135015

74

3

11. 8. 2016

Picklist Print

Page 9

July 08, 2016 10:32:45 AM

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

MS27039-1-23

Purchased

No

100

Each

53.0000

1

3

MS27039-1-23

SCREW

124326

DAS

6

9-89

Location

Loc Qty

Loc Code

ST279

53

18057

3

m135043

50

MS51859-6

Purchased

No

100

Each

60.0000

8

24

MS51859-6

WASHER

DAS

6

9-89

Location

Loc Qty

Loc Code

st268

60

m134502

60

MS51859-7

Purchased

No

100

Each

121.0000

2

6

MS51859-7

Washer

DAS

6

9-89

Location

Loc Qty

Loc Code

st268

121

M132576

21

M135058

100

MS51859-8

Purchased

No

100

Each

276.0000

8

24

MS51859-8

Washer

DAS

6

9-89

Location

Loc Qty

Loc Code

st268

276

m134606

276

JUL 28 2016

Picklist Print

July 08, 2016 10:32:45 AM

Page 10

Work Order ID: 148785

Parent Item: PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

148785

PB67-43001-03

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149DN632J Purchased No 100 Each 593.0000 4 12

NAS1149DN632J

Washer

DAS

6

9-89

Location

Loc Qty

Loc Code

ST265

593

m134370

593

NAS1149F0316P Purchased No 100 Each 143.0000 1 3

NAS1149F0316P

WASHER

DAS

6

9-89

Location

Loc Qty

Loc Code

ST262

143

M132579

143

NAS1149F0432P Purchased No 100 Each 1,515.000 16 48

NAS1149F0432P

WASHER

DAS

6

9-89

Location

Loc Qty

Loc Code

ST260a

1000

M134955

1000

ST262

515

M134502

515

NAS1149F0532P Purchased No 100 Each 2,436.000 2 6

NAS1149F0532P

Washer

DAS

6

9-89

Location

Loc Qty

Loc Code

ST260a

600

m133725

600

ST262

1836

18057

1836

JUL 28 2016

Picklist Print

July 08, 2016 10:32:45 AM

Page 11

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149F0632P

Purchased

No

100

Each

175.0000

8

24

DAS

NAS1149F0632P

WASHER

Location

Loc Qty

Loc Code

ST262

175

18057

4

m134497

171

27

NAS1149F0832P

Purchased

No

100

Each

123.0000

2

6

DAS

NAS1149F0832P

WASHER

Location

Loc Qty

Loc Code

ST262

123

18057

123

6

NAS43DD3-61

Purchased

No

100

Each

13.0000

1

3

DAS

NAS43DD3-61

Spacer

Location

Loc Qty

Loc Code

ST550

13

m128635

13

3

PB67-43001-09

Manufactured

No

100

Each

0.0000

1

3

08-6

PB67-43001-09

Aft Blade Fold Assembly Weldment

3148789 → 3

1 AUG 11 2016

PB67-43001-13

Manufactured

No

100

Each

0.0000

1

3

08-6

PB67-43001-13

Aft Adjustable Blade Support Assembly

3148823 → 3

08-6

Picklist Print

Page 12

July 08, 2016 10:32:45 AM

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-135

Manufactured

No

100

Each

6.0000

1

3

PR67-43001-135

Male Eye

**

100 9/2 2016

DAS

24

9-88

Location

Loc Qty

Loc Code

Mezz2

6

139212

6

100

Each

6.0000

1

3

PB67-43001-137

Manufactured

No

PR67-43001-137

Locking Sleeve

**

Location

Loc Qty

Loc Code

Mezz2

6

100004

1

133704

1

139213

4

100

Each

15.0000

1

3

PB67-43001-155

Manufactured

No

PR67-43001-155

Pin

**

Location

Loc Qty

Loc Code

Mezz2

15

133705

3

142807

12

100

Each

0.0000

1

3

PB67-43001-17

Manufactured

No

PR67-43001-17

Aft Adjustable Blade Support Assembly

**

3148824 → 3

DAS

24

9-88

PB67-43001-21

Manufactured

No

PR67-43001-21

Upper Blade Support And Cover Assembly

**

3148824 → 3

Location

Loc Qty

Loc Code

Mezz2

4

142800

4

July 08, 2016 10:32:45 AM

Shop Packet Print

Page 12

Picklist Print

July 08, 2016 10:32:45 AM

Page 13

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PR67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-23

Manufactured No

100

Each

6.0000

1

3

PR67-43001-23

Lower Blade Support And Cover Assembly

Location

Loc Qty

Loc Code

Mezz2

6

6

100

Each

7.0000

2

6

PB67-43001-261

Manufactured No

PR67-43001-261

Lever Arm

Location

Loc Qty

Loc Code

Mezz2

7

7

100

Each

29.0000

5

15

PB67-43001-265

Manufactured No

PR67-43001-265

Deltin Bushing

Location

Loc Qty

Loc Code

Mezz2

29

29

100

Each

17.0000

2

6

PB67-43001-299

Manufactured No

PR67-43001-299

Bushing

Location

Loc Qty

Loc Code

Mezz2

17

17

100

Each

2.0000

1

3

PB67-43001-305

Manufactured No

PR67-43001-305

Bearing

Location

Loc Qty

Loc Code

Mezz2

2

2

July 08, 2016 10:32:45 AM

Shop Packet Print

Page 13

Picklist Print

July 08, 2016 10:32:45 AM

Page 14

Work Order ID: 148785

148785

Parent Item: PB67-43001-03

PB67-43001-03

Parent Item Name: Aft Blade Fold Assembly

Start Date: 7/8/2016

Required Date: 8/3/2016

Start Qty: 3.00

Required Qty: 3.00

PB67-43001-37

Manufactured No

100 Each

4.0000 1 3

✓ ***PB67-43001-37***

Tube Arm Assembly

3

C

Location

Loc Qty

Loc Code

Mezz2

4

140779

1

142797

3

~~3~~ 1

2

PB67-43001-57

Manufactured No

100 Each

3.0000 1 3

✓ ***PB67-43001-57***

Stabilizer Arm

3

C

Location

Loc Qty

Loc Code

Mezz2

3

142796

3

100 Each

3.0000 1 3

3

C

PB67-43001-59

Manufactured No

✓ ***PB67-43001-59***

Adjustable Attachment Arm

Location

Loc Qty

Loc Code

Mezz2

3

142794

3

100 Each

1.0000 1 3

1

DAS
24
9-89

AUG 02 2016

PB67-43001-63

Manufactured No

✗ ***PB67-43001-63***

Handle Assy

Location

Loc Qty

Loc Code

Mezz2

1

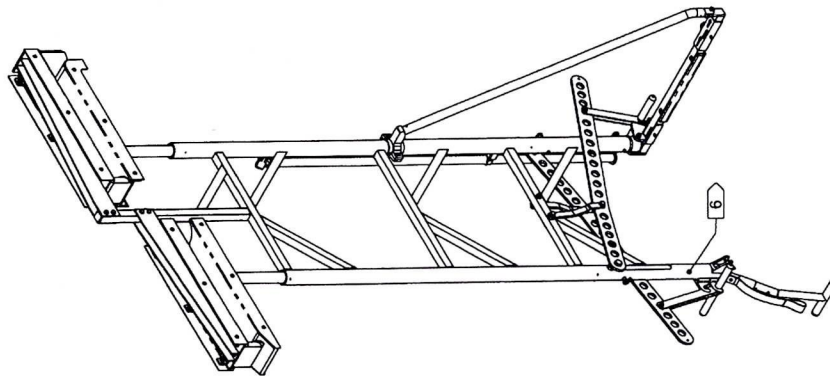
143784

1

1

149790

ITEM	QTY -03	P/N	DESCRIPTION
	X	B67-43001-03	AFT BLADE FOLD ASSY
1	1	B67-43001-09	AFT BLADE FOLD ASSY WELDMENT
2	1	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSY
3	1	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSY
4	1	B67-43001-21	UPPER BLADE SUPPORT AND COVER ASSY
5	1	B67-43001-23	LOWER BLADE SUPPORT AND COVER ASSY
6	1	B67-43001-37	TUBE ARM ASSEMBLY
7	1	B67-43001-57	STABILIZER ARM
8	1	B67-43001-59	ADJUSTABLE ATTACHMENT ARM
9	1	B67-43001-63	SHORT T-HANDLE ASSEMBLY
10	1	B67-43001-135	MALE EYE
11	1	B67-43001-137	LOCKING SLEEVE
12	1	B67-43001-155	PIN
13	2	B67-43001-261	LEVER ARM
14	5	B67-43001-265	DELIRIN BUSHING
15	2	B67-43001-299	BUSHING
16	1	B67-43001-305	BEARING
17	1	D3440-1	TUBE GUIDE
18	1	D3440-3	CLAMP
19	1	D3444-1	VELCRO LOOP BELT
20	2	D3447-9	SWING ARM
21	1	D3449-1	PAD
22	1	D3451-043	HANDLE & LOCK-DOWN ASSY
23	1	D3451-045	HANDLE & LOCK-DOWN ASSY
24	1	D3922-1	CLIP
25	1	30345T21	LANYARD
26	3	30345T24	LANYARD
27	1	3408A98	DETENT BALL PLUNGER
29	2	AN4-10A	BOLT
30	1	AN4-13A	BOLT
31	4	AN4-15A	BOLT
32	1	AN5-26A	BOLT
33	2	AN6-11A	BOLT
34	2	AN6-16A	BOLT
35	2	AN8-13A	BOLT
36	3	BSP43	RIVET
37	1	CR3213-405	RIVET
38	8	MS171534	SPRING SLOTTED TENSION PIN (OR 240-107)
39	1	MS17984-C408	QUICK RELEASE PIN
40	3	MS17984-C418	QUICK RELEASE PIN
41	9	MS21042L4	NUT
42	1	MS21042L5	NUT
43	4	MS21042L6	NUT
44	2	MS24694-S109	SCREW
45	1	MS27039-1-07	SCREW
46	1	MS27039-1-23	SCREW
47	8	MS51859-6	NYLON WASHER
48	2	MS51859-7	NYLON WASHER
49	8	MS51859-8	NYLON WASHER



B67-43001-03 AFT BLADE FOLD ASSY

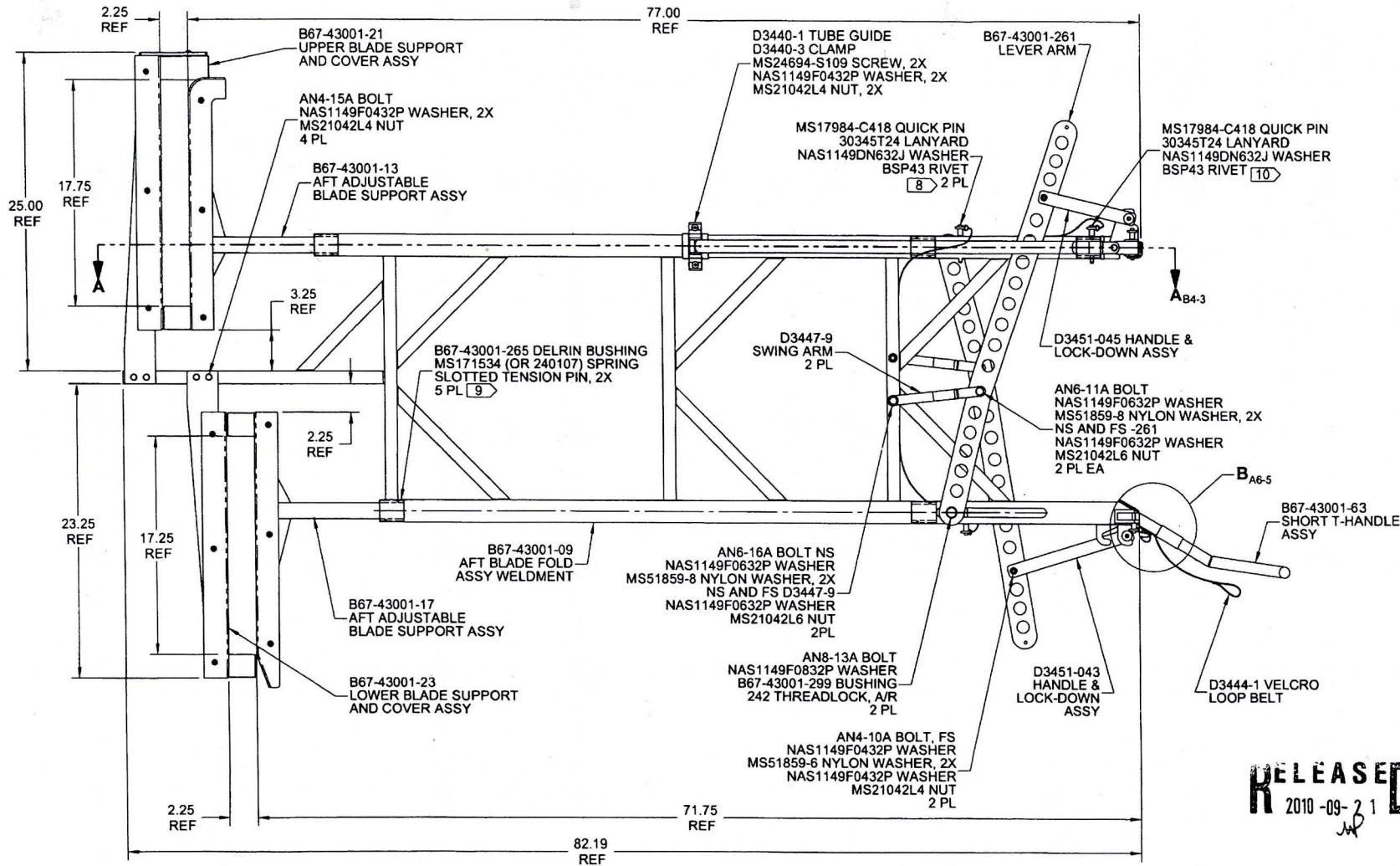
- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: TOUCH UP PAINT WITH SANDFLEX GREEN.
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 - 6) IDENTIFICATION: IDENTIFY WITH RED LABEL
 - 7) WEIGHT: 50.57 lbs
 - 8) WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS LOWEST MOST RECESSED POSITION, TRANSFER DRILL Ø0.250 DIA HOLE FROM THE OUTER TUBE TO THE INNER TUBE AND THRU THE OUTER TUBE. DEBURR, REMOVE DEBRIS, AND TOUCH UP PAINT PER ITEM 2 AS REQUIRED. 2 PL
 - 9) INSTALL TEFLON BUSHING -265 INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT MS171534 (OR 240170) SPRING SLOTTED PIN AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 10 PL (2 PL PER BUSHING)
 - 10) DRILL Ø0.250 DIA HOLE THRU -09/-265/-305 WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.
 - 12) DRILL A Ø0.128 DIA HOLE THRU -343 (COMPONENT OF -37) AND -25 (COMPONENT OF -09 ASSY). INSERT MS171534 (OR 240170) SPRING SLOTTED PIN, AND GRIND FLUSH WITH -37.
 - 13) INSERT -135 INTO -243 TUBE (COMPONENT OF -09 ASSY) ALIGN HOLES, ASSURING ORIENTATION SHOWN. INSERT 3408A98 DETENT BALL, ASSURING BALL PROTRUDES SLIGHTLY ABOVE OUTER SURFACE OF -243 TUBE. LOCATE AND INSTALL AN MS171534 (OR 240170) SPRING SLOTTED PIN BY DRILLING A Ø0.128 DIA HOLE THRU -243 AND -135. ENSURE -137 SLEEVE SLIDES FREELY OVER HINGE AND LOCKS INTO DETENT.
 - 14) BOND D3449-1 TO B67-43001-09 USING CONTACT CEMENT AS PER MANUFACTURER'S SPECIFICATION.

RELEASED
R 2010-09-21

5A 148785 7/12/16

REV.	DESCRIPTION	BY	DATE
C	REDRAWN PREMIER AVIATION DRAWING (AW DART OSI 018 AND OSI 043 FOR PREVIOUS REVISIONS. REFER TO SHEET 3 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011	VS	10.06.14
DESIGN	RW	DATE	
DRAWN	VS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.14		
DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA			
DRAWING NO. B67-43001-03			
REV. C			
SHEET 1 OF 5			
TITLE AFT BLADE FOLD ASSY			
SCALE NTS			
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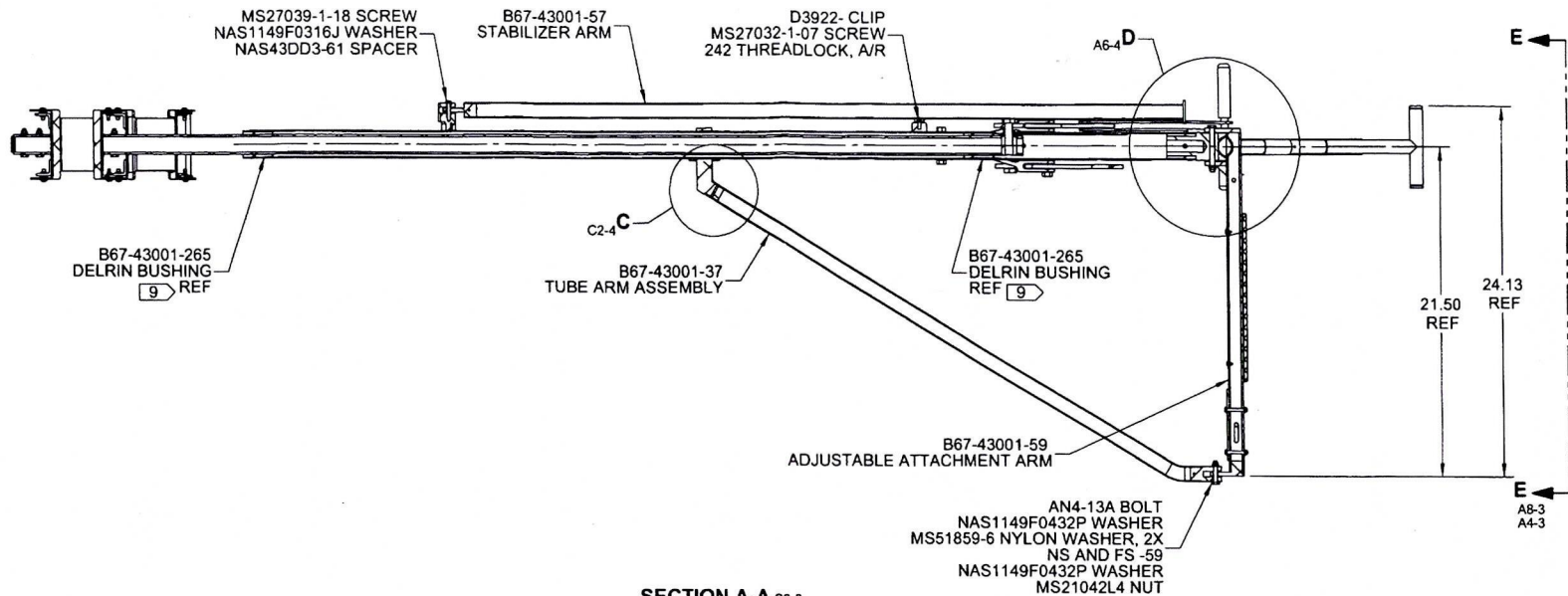


B67-43001-03 AFT BLADE FOLD ASSY

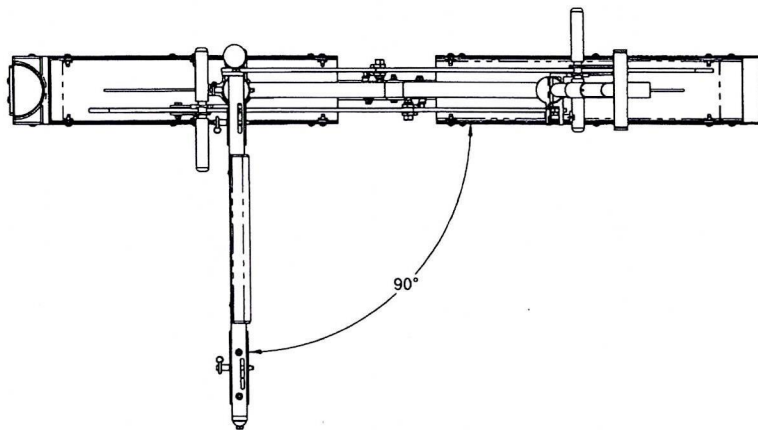
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DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	B67-43001-03	SHEET 2 OF 5
APPROVED	AM	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
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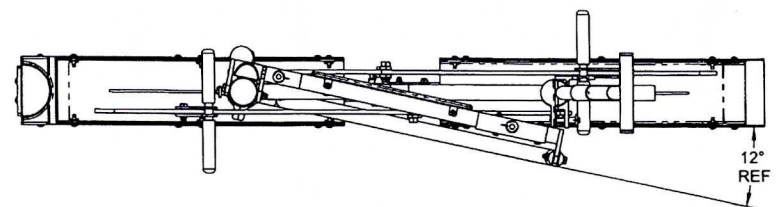
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SECTION A-A C2-2



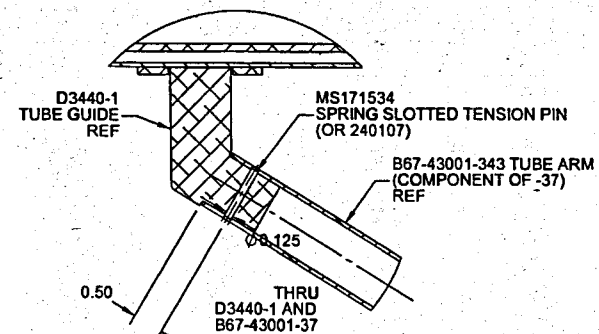
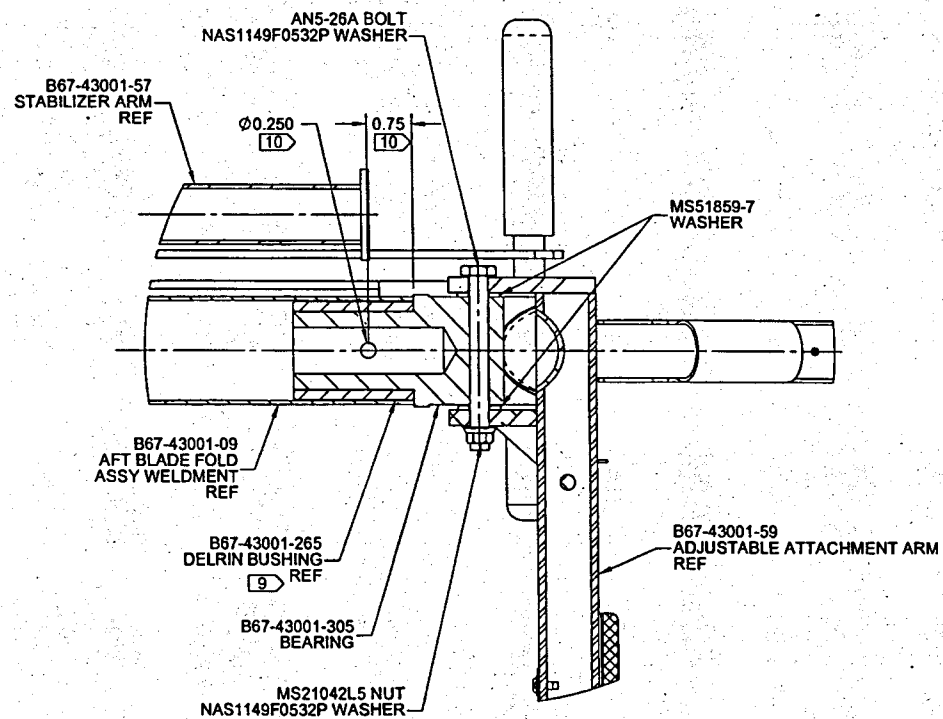
C1-3 VIEW E-E: VERTICAL FULL OPEN OR "IN USE" POSITION 10



C1-3 VIEW E-E: FULL CLOSED OR "STORAGE" POSITION 10

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2010-09-23

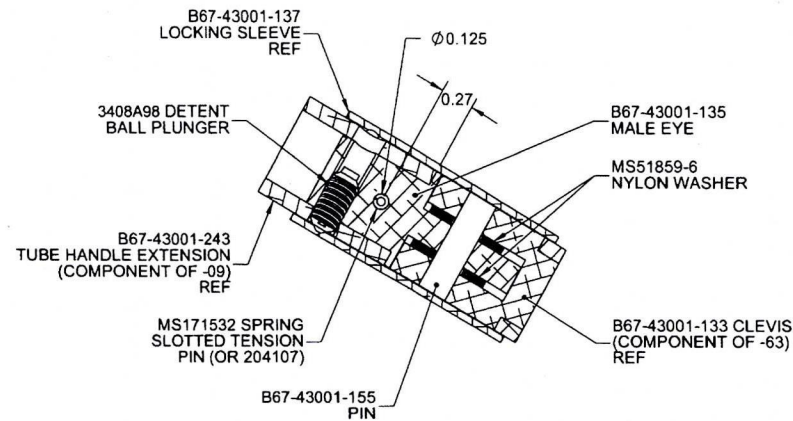
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DRAWN	VS		
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AS	B67-43001-03	SHEET 3 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	N/A	AFT BLADE FOLD ASSY	NTS
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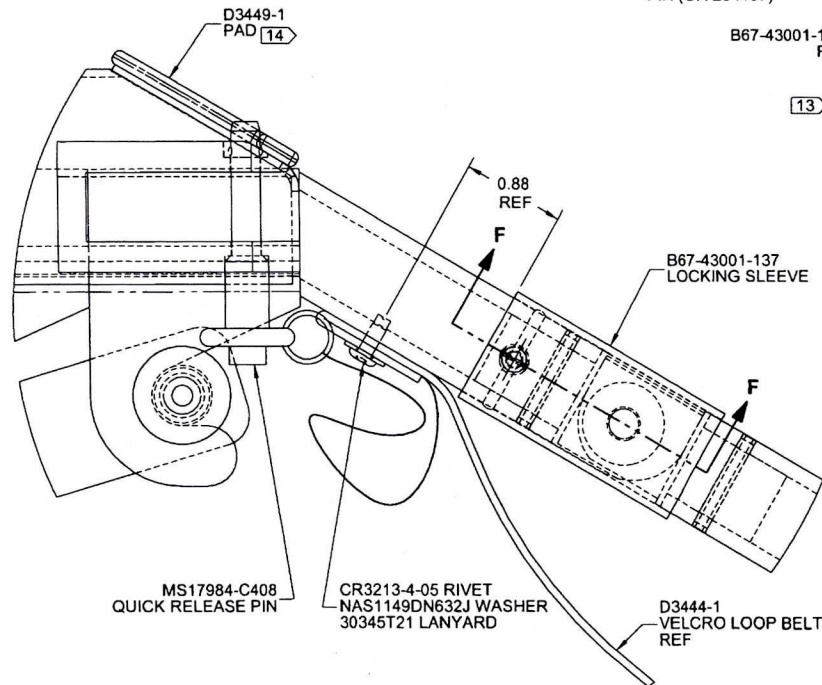
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2010-09-20
JN

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	V5		
CHECKED	JN	DRAWING NO. B67-43001-03	REV. C
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L 08461



13 SECTION F-F B4-5



13 DETAIL B C2-2
SCALE 10X

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MFG. APPR.		B67-43001-03	SHEET 5 OF 5
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